

Work Order ID 107532

September-27-13 11:23:42 AM

B 1 0 7 5 3 2

107532

Page 1

Item ID: D4435-045

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: T/R Bellcrank Cover Assembly

Start Date: 9/27/13

Start Qty: 8.00

8

Cust Item ID:

Required Date: 10/04/13

Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan: ML5

Date: 10-27

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4435

B

100

0.00

100

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

DAS

27

9-89

13/11/26

FF 13-11-26

Work Order ID 107532

September-27-13 11:23:42 AM

107532

Page 3

Item ID: D4435-045

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: T/R Bellcrank Cover Assembly

Start Date: 9/27/13 Start Qty: 8.00 ***8***

Cust Item ID:

Required Date: 10/04/13 Req'd Qty: 8.00 ***8***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

[Signature] / *Rm* 13/11/28
nwf
13-11-28

Picklist Print

September-27-13 11:23:41 AM

Page 1
12

Work Order ID: 107532

Parent Item: D4435-045

Parent Item Name: T/R Bellcrank Cover Assembly

Start Date: 9/27/13

Required Date: 10/04/13

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP RevB 11.12.22 per PA2 EC verified by:JLM IPP RevC 12.01.23 per REVA
DD verified by:EC IPP REV:D 12.03.06 AS PER DWG REV.B DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4435-5 Mount Bracket		Manufactured	No			100	Each	21.0000	1	8		FF 13-11-26	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				GA		10							
				103222		10							
				ST109		11							
				96353		11							
D4435-7 Bracket		Manufactured	No			100	Each	15.0000	1	8		FF 13-11-26	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				GA	109322	15							
				103223		12							
				80652		1							
				82321		2							
* MS20426AD3-3 Rivet		Purchased	No			100	Each	18,153.000	4	32		FF 13-11-26	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				Mezz	123352	18153							
				1173		8873							
				13276		9280							
MS20470AD4-3 Rivet - Universal Head		Purchased	No			100	Each	5,825.0000	4	32		FF 13-11-26	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				GA		1649							
				1642		157							
				2193		1492							
				ST335		4176							
				2193		4176							

DAS
36
9-89

Picklist Print

September-27-13 11:23:42 AM

Page 2

Work Order ID: 107532

Parent Item: D4435-045

Parent Item Name: T/R Bellcrank Cover Assembly

Start Date: 9/27/13

Required Date: 10/04/13

Start Qty: 8.00

Required Qty: 8.00

MS21059L3

Purchased

No

100

Each

195.0000

1

8

FF 13-11-26

Nut Plate

Location

Loc Qty

Loc Code

ST316

184

124291

7

125535

83

m126275

94

ST506

11

124308

11

MS21062L3

Purchased

No

100

Each

99.0000

1

8

FF 13-11-26

Nut Plate

Location

Loc Qty

Loc Code

ST317

99

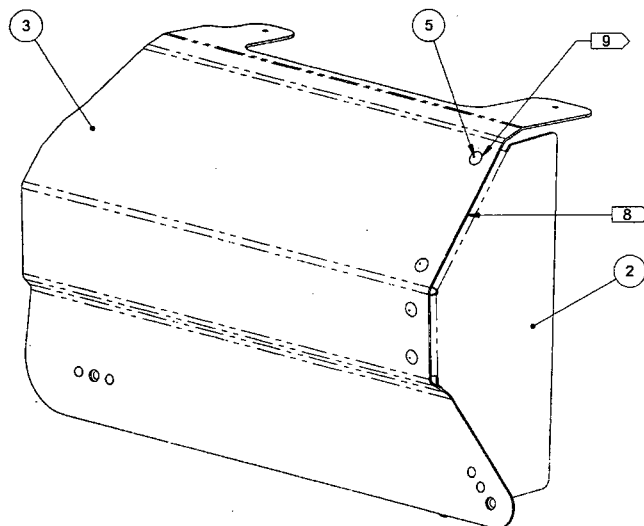
120930

24

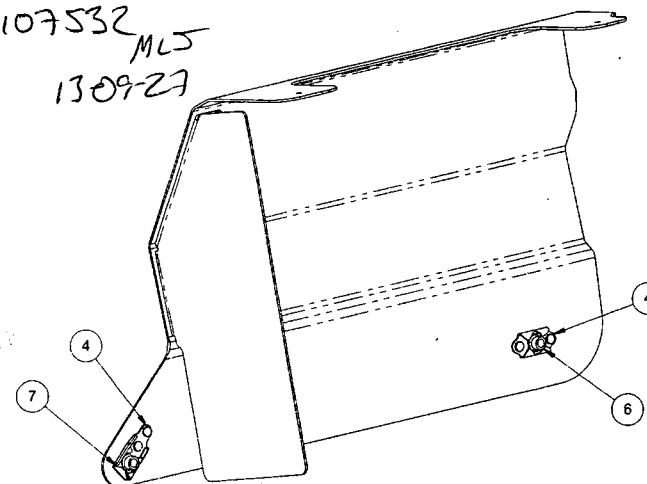
m126275

75

ITEM	QTY -045	PART NUMBER	DESCRIPTION
1	X	D4435-045	T/R BELLCRANK COVER ASSEMBLY
2	1	D4435-5	MOUNT BRACKET
3	1	D4435-7	BRACKET
4	4	MS20426AD3-2	RIVET
5	4	MS20470AD4-3	RIVET
6	1	MS21059L3	NUT PLATE
7	1	MS21062L3	NUT PLATE



107532
ML5
130927



D4435-045 T/R BELLCRANK COVER ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.371 lbs
- 8) INSTALL D4435-5 BRACKET SURFACE FLUSH WITH THIS EDGE
- 9) TRANSFER $\phi 0.129$ HOLES FROM D4435-5 MOUNT BRACKET INTO D4435-7 BRACKET

RELEASED
2012-03-02
JMM

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	MP	DRAWING NO.	REV. B
MFG. APPR.	BE	D4435	SHEET 3 OF 11
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	BRACKET	NTS
DATE	12.01.27	COPYRIGHT © 2012 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRELIMINARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

